

Work Order ID 131969

Tuesday, April 21, 2015 1:58:35 PM

131969

Page 1

Item ID: D5957 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: - Stop ***NS2***
Item Name: Saddle
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5957	Rev B

100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio D5957, Ensure Batch Number is entered 2-Machine Keyway 3-Debur & Tumble								

110	QC1- Inspection performed by CMM	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
20
9-89

15-06-23

DAS
44
9-89/15/06/22

P.T.O.

DAS
08
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed 15/08/28 Date: 15/08/28Work Order update only ☐

Work Order: <u>131969</u> Part No. <u>D5957</u> NCR No. <u>15-5282</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																				
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Description Work Order Deviation		Disposition																																																																																																																						
Spot faced .020" lower than top of island, entered wrong offset. I.C. operator enter wron offset not verified		DEVIATION ACCEPTABLE BASED ON HIGH MARGINS (REF SR-D205-594-1)		Completed By DAS 44 9-89 <u>15/06/22</u> Lead hand / Supervisor Approval Verification <u>[Signature]</u> <u>15/06/22</u> QC / QA Coordinator Approval DAS 9 9-89 <u>15-06-22</u>																																																																																																																				
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Page 2

AUG 25 2015

DQA:

Date: 15/09/02



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/08/28

Work Order update only

Work Order: 131969		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. D5957		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. 15-5283		Scrap ☒	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date: 15-06-23	Step #: 100	QTY Effective: ①				MRB (QSI042) Approval	
Description Work Order Deviation			Disposition				
Used wrong holes in part to locate it on jig. (Marked the Part)			Scrap + Destroy No Repair (Extra map)				
RC Tooling needs to be updated			Update Tooling				
			DAS 20 9-89 15-06-23 Modified bore on jig to fit small saddles.				
			Completed By DAS 20 9-89 15-06-23 Lead hand / Supervisor Approval Verification B. 15/06/23 QC / QA Coordinator Approval DAS 9 9-89 15-06-23				
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☒	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☒	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

Work Order ID 131969

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131969

Page 3

Item ID: D5957 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>st 399</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

AUG 26 2015

AUG 26 2015

20150826

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Page 1

Work Order ID: 131969

131969

Parent Item: D5957

D5957

Parent Item Name: Saddle

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			110	Each	27.0000	1	4			
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D6101-007

Saddle Billet

**

DAS
44
9-89

15/06/22.

Location

Loc Qty

Loc Code

MAT041

19

127646

1

131095

18

MAT044

8

116083

1

120494

7

→ 132722

5.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order: 131969
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.316	.316	.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.316	.316	.316		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.503	.504	.503	.497		
N	1.865	1.885		1.879	1.880	1.881	1.874		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.255	2.254	2.254	2.251		
Q	0.308	0.313		.311	.311	.310	.308		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.497	.495	.500	.496		
T	1.625	1.645		1.629	1.629	1.630	1.628		
U	2.000	2.020		2.002	2.002	2.004	2.004		
V	0.023	0.043		.033	.032	.037	.037		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

DAS

Measured by: 63
Date: 9-88 15/06/22 15-06-23

Audited by

DAS

Date:

15/06/29

08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

DART AEROSPACE LTD		Work Order: 131969
Description: Inner Aft Saddle		Part Number: D5957
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Inspect dimensions highlighted on inspection sheet drawing and record below:

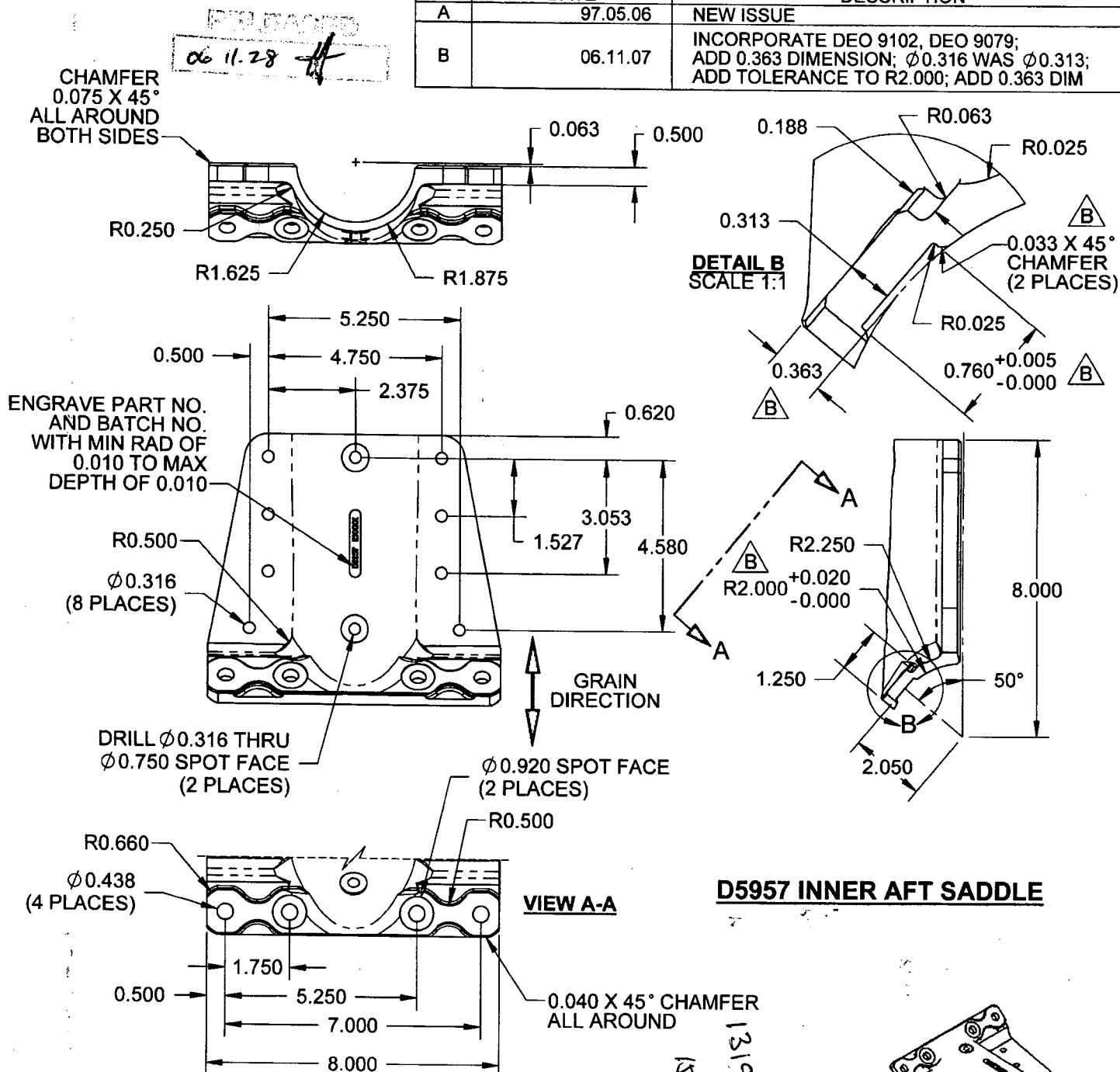
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443							
B	1.745	1.755							
C	5.245	5.255							
D	6.995	7.005							
E	5.240	5.260							
F	4.745	4.755							
G	0.315	0.322							
H	1.522	1.532							
I	3.048	3.058							
J	4.575	4.585							
K	0.315	0.322							
L	0.495	0.505							
M	0.490	0.510							
N	1.865	1.885							
O	7.990	8.010							
P	2.240	2.260							
Q	0.308	0.313							
R	0.760	0.765							
S	0.490	0.510							
T	1.625	1.645		1.629					
U	2.000	2.020							
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject				Scrap					

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Part Number: D5957	Rev: B	- Page 1 -
Description: INNER AFT SADDLE	Inspection Dwg: D5957	Work Order: 131969

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
D1	0.075	+0.010/-0.010	0.080	0.078	0.078	0.078	
D2	0.250	+0.010/-0.010	0.250	0.250	0.250	0.250	
3	1.625	+0.010/-0.010	1.626	1.625	1.625	1.626	
D4	1.875	+0.010/-0.010	1.876	1.875	1.875	1.875	
5	0.063	+0.010/-0.010	0.059	0.057	0.058	0.058	
6	0.500	+0.010/-0.010	0.499	0.501	0.501	0.502	
7	0.188	+0.010/-0.010	0.188	0.185	0.188	0.188	
D8	0.313	+0.000/-0.005	0.309	0.309	0.309	0.309	
9	0.363	+0.010/-0.010	0.363	0.361	0.363	0.365	
D10	0.760	+0.005/0.000	0.760	0.760	0.760	0.760	
D11	0.033	+0.010/-0.010	0.033	0.033	0.033	0.033	
12	8.000	+0.010/-0.010	7.999	8.001	8.000	8.001	
Ang13	50.000	+0.500/-0.500	50.030	50.027	50.014	50.013	
14	2.050	+0.005/0.000	2.051	2.053	2.052	2.054	
D15	1.250	+0.010/-0.010	1.253	1.253	1.253	1.251	
16	2.000	+0.010/-0.010	1.999	2.001	1.998	1.999	
D17	2.250	+0.010/-0.010	2.249	2.250	2.250	2.250	
18	0.500	+0.005/-0.005	0.501	0.500	0.502	0.500	
19	5.250	+0.005/-0.005	5.245	5.247	5.246	5.247	
20	4.750	+0.005/-0.005	4.747	4.747	4.746	4.748	
21	2.375	+0.005/-0.005	2.375	2.377	2.371	2.377	
22	0.620	+0.010/-0.010	0.621	0.621	0.623	0.621	
23	1.527	+0.005/-0.005	1.526	1.526	1.526	1.528	
24	3.053	+0.005/-0.005	3.053	3.054	3.053	3.054	
25	4.580	+0.005/-0.005	4.581	4.581	4.580	4.580	
26	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	
D27	0.750	+0.010/-0.010	0.749	0.750	0.750	0.750	
28	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	
29.000	0.438	+0.005/0.000	0.438	0.438	0.438	0.438	
30.000	0.500	+0.010/-0.010	0.498	0.499	0.492	0.495	
31	1.750	+0.005/-0.005	1.750	1.749	1.750	1.750	

Measured by:
Mathieu Lamarche

Date:
2015-8-20

Audited by:

Date:



Part Number: D5957	Rev: B	- Page 2 -
Description: INNER AFT SADDLE	Inspection Dwg: D5957	Work Order: 131969

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
32	5.250	+0.005/-0.005	5.251	5.250	5.252	5.250	
33	7.000	+0.005/-0.005	7.000	7.000	7.000	7.000	
34	8.000	+0.010/-0.010	8.000	8.001	8.001	8.001	
D35	0.040	+0.010/-0.010	0.040	0.040	0.040	0.040	
36	0.063	+0.010/-0.010	0.065	0.063	0.063	0.063	

Measured by:
Mathieu Lamarche

Date:
2015-8-20

Audited by:

Date: